

Date: Thursday, 18/10/2007 3:26:01 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STEP WELDMENT
Job Number	34270	Part Number	D3562042
Estimate Number	12577	Drawing Number	D3562 UNDER REVIEW
P.O. Number	N/A	Project Number	N/A
This Issue	18/10/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Revision	A
First Issue	27/08/2007	Type	LARGE FAB ASSY
Previous Run	34027	Material	N/A
Written By		Due Date	07/09/2007
Checked & Approved By		Qty:	6
Comment	Est Rev A	Um:	Each
Additional Product			

Job Number:



(PNS)

Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	34694

Check Material for any Dents or Defects

FF 07-10-31

(6)

2.0	D2734	206 Step Endplate
13.1		

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:	Qty Part Number	Description	Batch
	2 D2734	End Cap	334485

(6)

FF 07-10-31

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

FF 07-10-31

(6)

2-Deburr and bevel ends for welding

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.
A/R Aluminum Rod

4-Grind end cap welds flush as per Dwg D3562

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/11/08	#16.0	ADD A Step to allow the pre heating of the steps to be similar. SEND CARB after welding 15 min @ 320°C to dry off Dampus.					✓ 07/11/08
07/11/12		Press Bushing D 280 & Batch B 32896 MF in the arm.	✓	07-11-12	6		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #: Machine Or Opération:

Description :

4.0 QC5 INSPECT WORK TO CURRENT STEP



2011/01/01

(26)

Comment: INSPECT WORK TO CURRENT STEP

5.0 QC9 VISUAL WELDING INSPECTION



W

Comment: VISUAL WELDING INSPECTION

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 D3560042 ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT 34475

2011/01/01

b

9.0 D3560044 ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

Batch: 34477 = 5 35032 = 1

2011/01/02

b

10.0 MS20600AD4W5 Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 216.0000 Each(s)

Blind Rivet

batch: M105125 = 200

M106074 = 16

2011/01/02

b

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562. Touch up alodine.

2011/01/02

b

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Job Number: 34270

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Rivet legs using Magnabond as per dwg D3562.

Ensure to wipe off any excess magnabond of the step

A/R Magnabond 6398

Batch: M104677

PL 07-11-08 6

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 07/11/08 (6)

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

PL 07-11-08 6

2-Grind end cap welds flush, as per Dwg D3562

FF 07-11-08 6

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-11-08 (6)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 07/11/08 (6)

16.0

POWDER COATING

POWDER COATING



touch up alodine + FZ
pressure was 4
M105194

07/11/08 (6)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

H

07-11-09 (6)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M106030

B FZ

07/11/12 (6)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7-11-12 SD 6X

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19.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Package as step weldments only **do not assemble**	<i>draft 1/3 7/11/12 SP 6x</i>
20.0	QC21	FINAL INSPECTION/W/O RELEASE

Job Completion



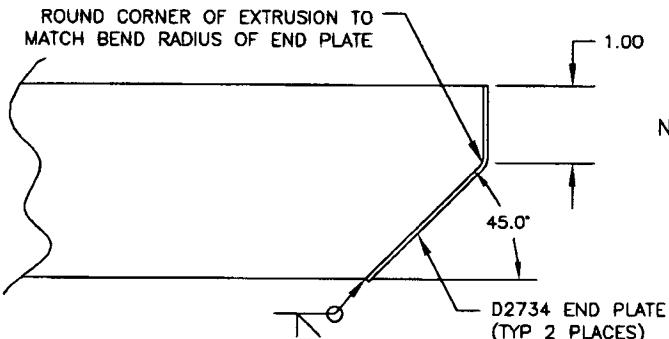
U 8.11.13

W/O:		WORK ORDER CHANGES					
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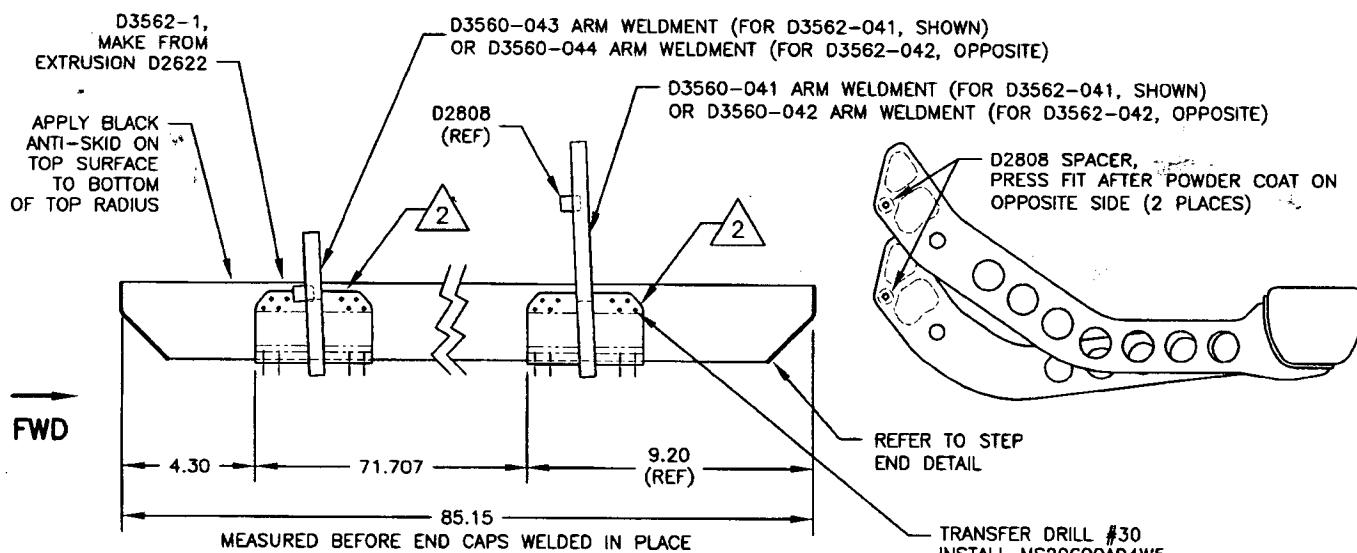
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DART**RELEASED**
07.06.29

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

**D3562-041 LH STEP ASSEMBLY (SHOWN)****D3562-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		DRAWING NO.
A	06.09.26	D3562
B	07.01.15	STEP ASSEMBLY
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTS

REV. C
SHEET 1 OF 1
SCALE
NTS

W/O:		WORK ORDER CHANGES					
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